Rev C 5/14/24

~~PRELIMINARY ISSUE~~

Work Order ID 111317

Wednesday, January 22, 2014 9:15:05 AM

111317

Item ID: D4652-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Air Valve, 1.16 Id Disk Type

Start Date: 1/10/2014 **Start Qty:** 12.00 *12*

Required Date: 1/17/2014 **Req'd Qty:** 12.00 *12*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** CL **Date:** 14/01/22 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / Revision Nbr		DAS 27							
D4652 / ~~B~~ PC2	Rev C 9-89 per EAN 14-509								
100		0.00							
100									
Purchasing		0.00							
Purchasing	Memo Issue P/O: 22649 Purchase Part Number: AV264301-2 Supplier: BIRK AEROSYSTEM CORPORATION Note:d4652-3 is included in the -1 Certificate of conformity is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging		0.00							
Packaging	Memo								

CL 14/01/22 12

14/1/22 (12)

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Work Order ID 111317

Wednesday, January 22, 2014 9:15:05 AM

111317

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Reference:

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Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				12			
120									
QC	**Memo**	0.00							
Quality Control									
130	Identify as per dwg & Stock Location:_____	0.00				MCJ	14-01-23		
130									
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00				MCJ	14-01-23		
140									
QC	**Memo**	0.00				AA	14-01-22		
Quality Control									

DAS 27 9-89 14/1/22

Inspect as per Dwg PC2

thermoforming

POSITIVE RECALL
EFFECTIVE 14.01.22 AUTH
RELEASED DATE 14/1/24

DAS 27 9-89

Release Dwg as per Rev C 14/1/23

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Over/Under tolerance
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Picklist Print

Wednesday, January 22, 2014 9:15:05 AM

Work Order ID: 111317

Parent Item: D4652-1

Parent Item Name: Air Valve, 1.16 Id Disk Type

Start Date: 1/10/2014 **Required Date:** 1/17/2014

Start Qty: 12.00 **Required Qty:** 12.00

Comments: Ipp RevA 12.05.31 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AV364302-QCP820 Air Valve (Satin Black)		Manufactured	No				Each	0.0000		**12**			

Cap'd 1/22 (12)

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

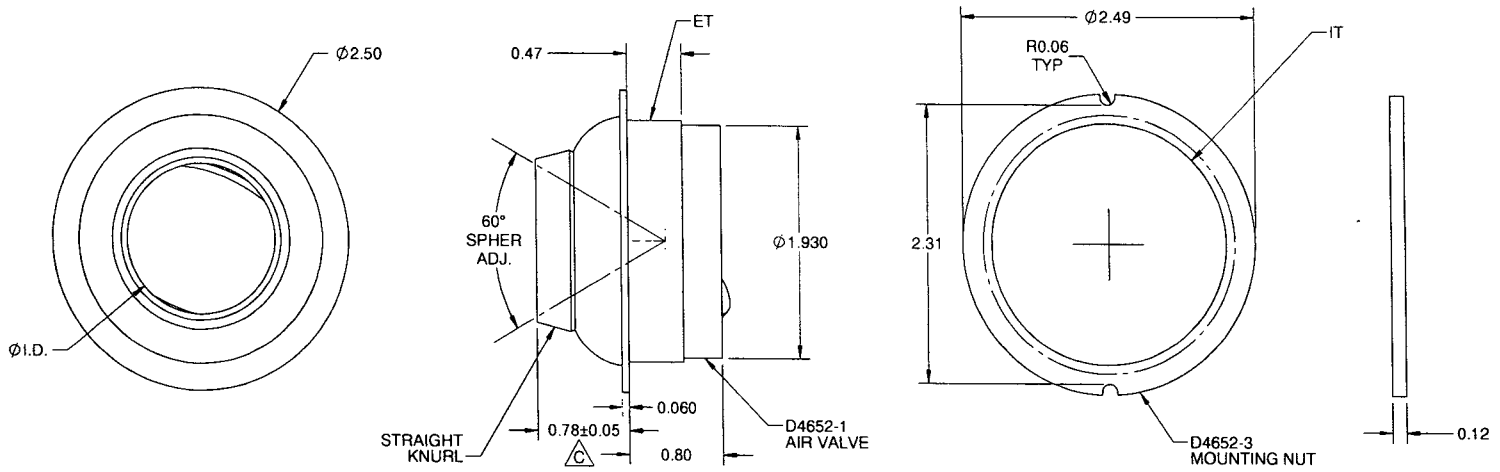
Landing Gear

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☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

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☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
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☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

SPECIFICATION CONTROL DRAWING



D4652-X AIR VALVE/ MOUNTING NUT

DART PART NUMBER	DESCRIPTION	VENDOR	VENDOR PART NUMBER	MATERIAL	FINISH	INSIDE DIAMETER "ID"	MOUNTING NUT TYPE	EXTERNAL THREAD "ET"	INTERNAL THREADS "IT"	WEIGHT (lbs)
D4652-1	AIR VALVE	BIRK AEROSPACE CORPORATION	AV364302	ALUMINUM	QCP820 SATIN BLACK	1.25	ALUMINUM	2.00-24 UNS-2A	N/A	0.08
D4652-3	MOUNTING NUT	BIRK AEROSPACE CORPORATION	MN8005-1	ALUMINUM	QCP820 SATIN BLACK	N/A	ALUMINUM	N/A	2.00-24 UNS-2B	0.02

14/01/22
W10.111317

NOTES:
1) MATERIAL: PER TABLE
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: PER TABLE

REV.	DESCRIPTION	BY	DATE
C	REVISE VENDOR P/N AND SPECIFICATIONS & REMOVED NOTE 8) (ZN B4-1,B5-1, B6-1 & A8-1)	RF	13.11.08
B	ADD P/N TABLE/DESCRIPTION	RF	12.11.30
A	NEW ISSUE	RF	12.07.25

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4652 REV. PC2
MFG. APPR.		SHEET 1 OF 1
APPROVED		TITLE AIR VALVE SCALE NTS
DE APPR.		
DATE	13.11.08	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22049

Purchase Order Date 11/14/2013
PO Print Date 1/21/2014

Order From : VU-BIR001

BIRK AEROSYSTEMS CORPORATION
14321 COMMERCIAL DRIVE
GARDEN GROVE, CALIFORNIA 92843

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 714-554-9782
Ship To Contact
Ship To Phone
Ship Via: FedEx PI collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB FCA – (Free Carrier)

1	AV364302-QCP820	Air Valve (Satin Black)	1/3/2014 No 1/3/2014	12.00 Each		$488.92	$5,867.04

B11 13/7

NOTE
Price to be adjusted at a later date.

6/4/22

Line Total: **$5,867.04**

2	AV364302-QCP820	Air Valve (Satin Black)	1/21/2014 No 1/21/2014	12.00 Each		$262.03	$3,144.36

NOTE
Pricing to be advised.

Line Total: **$3,144.36**

PO Total: **$34,166.28**

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.
No substitution or deviation without consent.
Certificate of Conformity or Material Certification required - YES NO
PST# 6122-5207

Change Nbr: 9 **Change Date:** 1/21/2014

BAC
BIRK AEROSYSTEMS CORPORATION
14321 Commerce Drive
Garden Grove, California 92843
Telephone: (714) 554-9782 Telefax: (714) 554-3659

DATE: 01/17/14
CUSTOMER PO: PO22049
SHIPPER NO.: DAR140117

CERTIFICATE OF CONFORMITY / PACKING LIST

SHIP TO: **DART AEROSPACE LTD**
823 Mactavish Road
Calgary, AB T2E 7G9
Canada

PO ITEM	PRODUCT NO.	DESCRIPTION	QUANTITY ORDERED	QUANTITY SHIPPED	LOT CODE	LOT QTY	SERIAL NO.
1	AV364302-QCP820	Air Valve (Rev. -)	12	12	1401540 MFG: 1403	12	-
		VALUE FOR CUSTOMS: $3144.36 USD Country of Manufacture: United States					

CLAIMS FOR SHORTAGES OR MATERIAL DISCREPANCY MUST BE MADE WITHIN 15 DAYS AFTER DATE SHIPPED.
CERTIFICATE OF CONFORMANCE: THIS IS TO CERTIFY THAT THE PARTS FURNISHED ON THIS ORDER HAVE BEEN FUNCTIONALLY TESTED IN ACCORDANCE WITH STANDARD PROCEDURES DEFINED BY BAC. MATERIAL AND/OR PARTS FURNISHED IN THIS ORDER HAVE BEEN MANUFACTURED IN ACCORDANCE WITH ALL APPLICABLE INSTRUCTIONS AND SPECIFICATIONS. PHYSICAL AND CHEMICAL DATA WHICH PERTAINS TO THIS ORDER ARE AVAILABLE FOR INSPECTION.

FEDEX P1 COLLECT
4#

QTY VERF BAC 2

BAC 3

QUALITY CONTROL INSPECTOR

DART AEROSPACE LTD

DART AEROSPACE

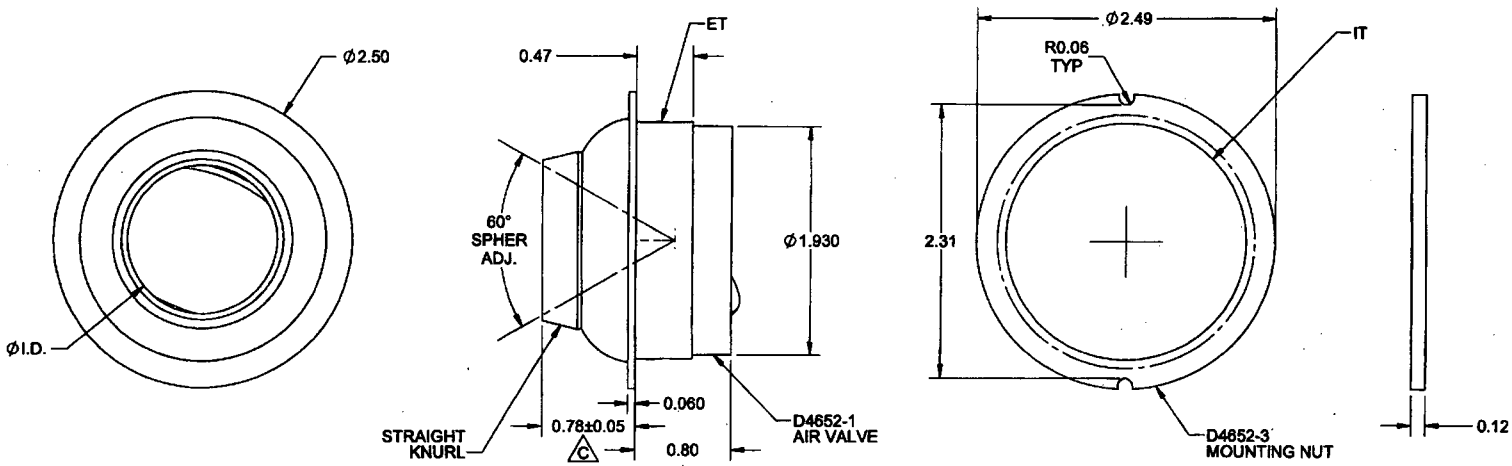
Description:	Air Valve	Work Order:	B111317
Inspection Drawing:	D4652	Rev:	Part Number: D4652-1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 2.50	+/- 0.030	2.494	✓		V	QC1 - 07
Ø 2.00	+/- 0.030	2.001	✓		V	"
0.47	+/- 0.030	0.47	✓		V	"
Ø 1.930	+/- 0.010	1.943	✓		V	"
0.060	+/- 0.030	0.58	✓		V	"
0.80	+/- 0.030	0.786	✓		V	"
~~0.18~~	~~+/- 0.05~~		✓		V	"
Ø 2.49	+/- 0.030	2.49	✓		V	"
0.12	+/- 0.030	1.255	✓		V	"
2.31	+/- 0.030	2.319	✓		V	"
60°	+/- 2	60°	✓		S	"
1.25	+/- 0.030	1.246	✓		V	"

Measured by: DAS 27 9-89	Checked By:	QC inspector:	Engineering Approval *(if necessary)*:
Date 14/11/22	Date	Date	Date

SPECIFICATION CONTROL DRAWING



D4652-X AIR VALVE/ MOUNTING NUT

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NOTES:
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2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: PER TABLE
C 8) PURCHASE VENDOR ASSEMBLY P/N AV364302-QCP820. VENDOR ASSEMBLY INCLUDES AV364302 AND MN8005-1

REV.	DESCRIPTION	BY	DATE
C	REVISE VENDOR P/N AND SPECIFICATIONS (ZN B4-1,B5-1, B6-1 & A8-1)	RF	13.11.08
B	ADD P/N TABLE/DESCRIPTION	RF	12.11.30
A	NEW ISSUE	RF	12.07.25

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	SC	DRAWING NO. D4652 REV. C
MFG. APPR.	MG	SHEET 1 OF 1
APPROVED		TITLE AIR VALVE SCALE NTS
DE APPR.		
DATE	13.11.08	

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